



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2010-104
Job Sheet 180699



Part No: D2010-104

Job Qty: 4 ea

Part Name: Arm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.02.17 New issue KJ/JLM IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC IPP
Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	7/26/18	7/26/18	0.00	0.00	Start Up Small Fab-4		DAS 58
100	Brake NC	4 pcs	7/26/18	7/26/18	0.00	1.30	Brake NC 3		DAS 58 17/1/25
110	Small Fab	4 pcs	7/26/18	7/26/18	0.00	1.00	Small Fab-1		DAS 58 17/1/25
120	Small Fab	4 pcs	7/26/18	7/26/18	0.00	0.82	Small Fab-1		DAS 58 17/1/25
130	QC	4 pcs	7/26/18	7/26/18	0.00	0.00	QC5		DAS 58 17/1/25
140	Powdercoat	4 pcs	7/26/18	7/26/18	0.00	0.12	Powdercoat4		DAS 58 17/1/25
150	QC	4 pcs	7/26/18	7/26/18	0.00	0.00	QC3		DAS 58 17/1/25
160	Packaging	4 pcs	7/26/18	7/26/18	0.00	0.00	Packaging3-1		DAS 58 17/1/25
170	QC21-SA	4 Ea	7/26/18	7/26/18	0.00	0.00	QC21		DAS 58 17/1/25

Part Op 100 - Punch per Dwg. D2010-104 and Spec Control Dwg D2727 Identify as D2010-104

Descriptions: 110 - 1- Bend as per Dwg D2010 using bending Jig D2010-104T2 2- flare before installing plug as per dwg D2010 3- Install D2057 plug as per Dwg D2010

120 - 1- flare before installing plug as per dwg D2010 2- Install D2057 plug as per Dwg D2010

140 - START TIME: 10:10 OVEN TEMPERATURE: 350° FINISH: 10:40

M13870

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TR0.500W.049	304 Round Tube .500 X .049W	6 ft (1.5 ea)	90-Start up Operation	5092699
D2057	Plug	4 Ea (1 ea)	110-Small Fab	5030905

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TR0.500W.049	6	105	0
110-Small Fab	D2057	4	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm	7.900inches ± 0.030	7.930 7.870		
2	Arm	10.200 ± 0.030			
3	Arm	45.000Degree ± 0.500	45.500		

			44.500
4	Arm	45.000Degrees $\pm$ 0.500	45.500
			44.500
5	Arm	0.600inches + 0.008 - 0.001	0.608
			0.599

Plex 7/12/18 7:38 AM Dart.lajeunesse.marie

Work Order update only

Date: 07/25/18